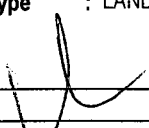
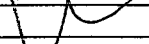













Date: Friday, 09/03/2007 7:26:06 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 FWD X-TUBE
Job Number	: 31151	Part Number	: D407667105
Estimate Number	: 12348	Drawing Number	: D407-667-145 REV B
P.O. Number	: <i>N/A</i>	Project Number	: <i>N/A</i>
This Issue	: 09/03/2007	Drawing Revision	: <i>N/A</i>
Prsht Rev.	: <i>NC</i>	Material	: <i>N/A</i>
First Issue	: <i>NA</i>	Due Date	: 16/03/2007
Previous Run	: 31054	Qty:	1 Um: Each
Written By	: 		
Checked & Approved By	: 		
Comment	: Est Rev: F 05.09.01 Add holes for compatibility with Bell Skid tubes KJ/JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D206-667-105 CHG002			
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
			
Comment: LANDING GEAR RESOURCE 1 PULL FROM STOCK 1 X D407-667-105 B <i>19142</i> CHG001 1 X D407-667-105 B _____ CHG001			
3.0	D407667105	FWD Crosstube	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) FWD Crosstube			
4.0	D2856400	Abrasion Strip	
			
Comment: Qty.: 1.2138 f(s)/Unit Total: 1.2138 f(s) Pick: Qty Part number Description Batch 2 D2856-400(Cut to 6.94") Abrasion Strip _____			
5.0	D2873043	Nut Plate Assembly	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part number Description Batch <i>31192</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/03/2007 7:26:06 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 31151

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2873-043

Nut Plate

6.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

B29107

RT 07-03-28

7.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1

Support

N/A

Already installed

8.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

M103395

RT 07-03-28

9.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D407-667-145. Torque clamps to 80-100 in lb.

3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.

N/A Already installed

RT 07-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/03/2007 7:26:06 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 31151

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-17

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING
REPAINT CUFFS

07-04-12

13.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

07-04-12

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

15.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
Batch: 00 Batch M11931 4X

16.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Nut
Batch: 00 Batch M5285 4X

17.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)
Batch: M104093 1X M10232F 9X

18.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch M1020F3

07/4/18

Date: Friday, 09/03/2007 7:26:06 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 31151

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-30A

Bolt

19.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer

M102519 10X

OLD BATCH

M M1989 8X

7/4/18

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-667-105

Location:

PPP Rev:

B

7/4/18 SQ

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/19

Job Completion



u 8.24.19

DART			
TRANSPORT CANADA APPROVAL #09-89			
TEL: 1-613-632-4336	FAX: 1-613-632-4443		
P/N	D407-667-105	CHG	CHG001
DESC	Crosstube Fwd High	SIC	SH01-5
LOT	B19142	SIC	SR01304NY
MODEL	Bell 407	SIC	
MADE IN CANADA			